

Date: Monday, 10/30/2006 7:40:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER
 Job Number : 29199
 Estimate Number : 10376
 P.O. Number : *N/A*
 This Issue : 10/30/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : 27969
 Part Number : D2885
 Drawing Number : D2885 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 11/3/2006 Qty: 40 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06 10 30
 Comment : Est A 99.10.12 New Issue EC
 Est Rev:B Now 6060-T6 06-06-23 JLM
 Est Rev:C waterjet 06-07-23 ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0270 sf(s)/Unit Total : 1.0794 sf(s)
 Material: 6061-T6 (QQ-A-250/8) 0.080" Thick
 Batch *M101178*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

SAD 06:11:04

40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:11:04

40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/11/06

counted

37

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

FLY

06/11/22

x 37

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-20	4.1	Delat	SAD	06-11-19	40		
		Add delat step - permanent change	E	06-12-04			06-11-20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 7:40:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 29199

Part Number: D2885

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/23

37

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 393

06/11/23

37

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/07

37

Job Completion



06.11.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29199
Description: Saddle Spacer		Part Number:	D2885
Inspection Dwg: D2885 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

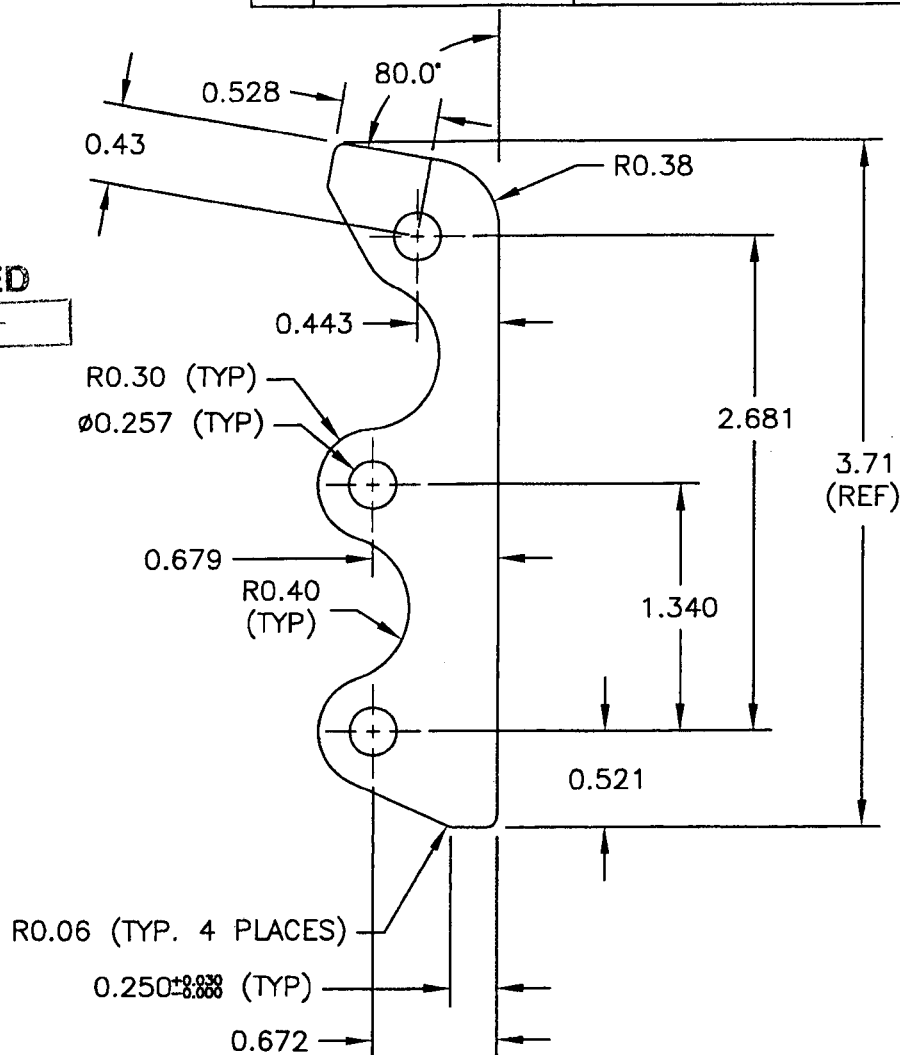
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	0.43	✓		Vern	
0.443	+/-0.010	0.448	✓		Vern	
Ø0.257	+0.006/-0.001	Ø0.256	✓		Vern	
R0.30	+/-0.030	R0.30	✓		R-G	
0.679	+/-0.010	0.685	✓		Vern	
R0.40	+/-0.030	R0.40	✓		R-G	
0.250	+0.030/-0.000	0.250	✓		Vertical Vern	
0.672	+/-0.010	0.677	✓		Vern	
0.521	+/-0.010	0.524	✓		Vertical Vern	
1.340	+/-0.010	1.345	✓		Vern	
2.681	+/-0.010	2.690	✓		Vern	
3.71	+/-0.030	3.704	✓		Vern	
R0.38	+/-0.030	R0.38	✓		R-G	
0.528	+/-0.010	0.528	✓		Vertical Vern	
0.080°	+/-0.5°	0.079	✓		Vern	

Measured by: SAD	Audited by: MA	Prototype Approval:	N/A
Date: 06/11/04	Date: 06/11/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*06-06-10***NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
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